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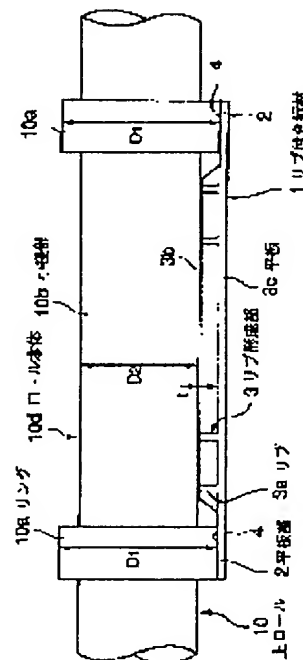
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## (54) FORMING METHOD AND EQUIPMENT FOR RIBBED PLATE MATERIAL

## (57)Abstract:

PROBLEM TO BE SOLVED: To provide a forming method and equipment to obtain high-quality formed products without occurrence of processing defects such as breakage or processing unevenness due to abnormal deformation when processing, with less processing man-hours not requiring adjustment of pressure of the upper and lower rolls when a ribbed plate material consisting of peripheral flat plate portions and a rib-formed portion at the center is bent and formed.

SOLUTION: In a method of forming a ribbed plate material 1 in such a way that the rib side will be on the inner bent side by pressing the ribbed plate material 1 with flat plate portions of specified width and the rib-formed portion with multiple grid or stripe ribs of a fixed height formed on the flat plate between the upper roll 10 and a pair of two lower rolls, at least two portions of the upper roll 10 are made larger in diameter than the small-diameter portion 10b and the flat plate portions 2 of the plate material is pressed between the large-diameter portions and the lower rolls, and a fine clearance is formed between the small-diameter portion 10b and the top face of the rib before processing, and the small-diameter portion 10b and the top face of the rib are brought into contact with each other during the processing, so as to perform bending.



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